

Date: Wednesday, 3/26/2008 7:40:49 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 38190	
Estimate Number : 11147	
P.O. Number :	Part Number : D3209041
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D3209 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 37170	Material :
Written By :	Due Date : 4/7/2008 Qty: 6 Um: Each
Checked & Approved By : <u>08 03 26</u>	
Comment : Est A 04.06.09 New issue KJ/RF	

Additional Product

Job Number:



Seq #:

Machine Or Operation:

Description:

Estimate Number: M6061T6B1500X01250

6061-T6 Bar 1.5" x 1.25"

Job Number:



Job Issue:

Comment: Qty.: 0.1838 f(s)/Unit Total: 0.7350 f(s)

NO BACK IN THE COMPUTER

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)

(M6061T6B1.500x01.250)

Identify for D3209-1

Batch: 7104183

08/03/30

⑥

2.0

BAND SAW

BAND SAW



Comment: BAND SAW.

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

08/03/30

⑥

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3209-1 as per Folio FA345 and Dwg D3209

Identify as D3209-1

Deburr and Tumble

08/04/12

08/04/12

⑥

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/04/12

08/04/12

⑤

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/04/12

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 7:40:49 AM
User: Kim Johnston

Process Sheet

30 min.
17/04/2008

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

S.050 15.29

Job Number: 38190

Part Number: D3209041

#1 322.5 F

#2 38190 F

#3 3209041 F

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



⑥

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-15

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 106442

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the hole for D3209-1 before powder coat.

BR 08-04-17 ⑥

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/04/18 ⑥

9.0

D32093

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

1 D3209-3 Bushing

Press fit bushing into the bracket as per Dwg D3209

B 25907

BR 08/04/21 ⑥
FL 8/4/18 ⑥

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/21 ⑥

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 77

8/4/21

SLP

⑥x

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/22

Job Completion



mk 08-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

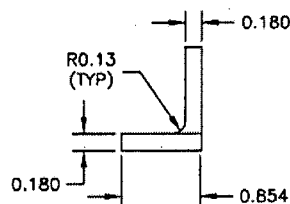
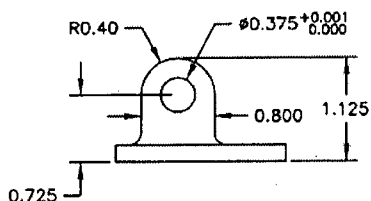
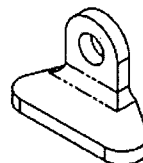
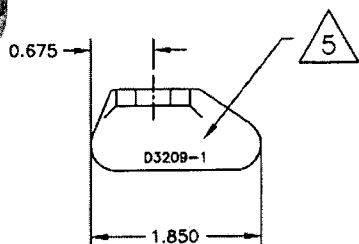
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



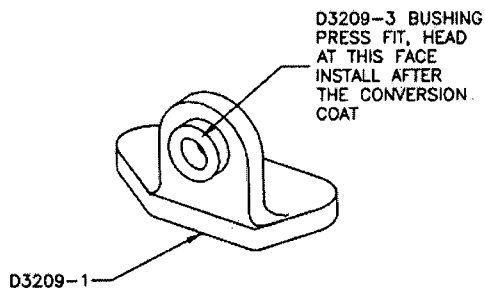
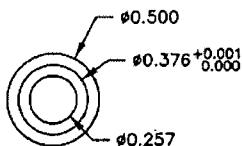
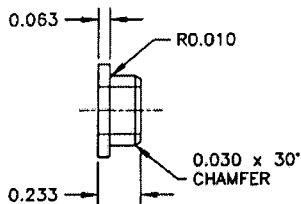
DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 *[Signature]*



2

D3209-1 BRACKET



4

D3209-041 ASSEMBLY

3

**D3209-3 BUSHING
SCALE 1:2**

D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

NO. 28990
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
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SHOP COPY

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